

Date: Tuesday, 01/04/2008 10:28:04 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WINDOW
Job Number	: 38266		
Estimate Number	: 10003		
P.O. Number	:	Part Number	: D2214
This Issue	: 01/04/2008 S.O. No. :	Drawing Number	: D2214 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL / MED FAB	Drawing Revision	: C
Previous Run	: 34526	Material	:
Written By	: <u>02.07.01.</u>	Due Date	: 08/04/2008 Qty: 10 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: C 99.04.29 Added New Jig and Part Numbers DM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MACRLICS125	1/8" Polycast II Sheet
-----	-------------	------------------------



Comment: Qty.: 0.7960 sf(s)/Unit Total : 7.9600 sf(s)

1/8" Polycast Sheet

(M-acrylic-S.125)

BATCH: 10674 B 8-4-2

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D2214

Dwg Rev: C B 8-4-2Prog Rev: C

2-Debur if necessary

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

B 8-4-2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

no ~~in~~ cracks or defects  
fnew

Comment: SECOND CHECK

08/04/02 (10)

5.0	D27281	Dart Logo label small
-----	--------	-----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2728-1	DART logo	<u>B24215</u>

08/04/03

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW

Job Number: 38266

Part Number: D2214

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

D2462

Neoprene Seal



Comment: Qty.: 3.6700 f(s)/Unit Total : 36.7000 f(s)  
Neoprene Seal



Pick:

Qty Part Number Description  
44" D2462 SEAL

Batch  
B29456

B08/04/03

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2462 Seal to length and Install around edge

2-Transfer holes through seal

3-Attach small DART logo labels D2728-1as per template DT 8223

PTU

B08/04/03 (8)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

B08/04/03 (48)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Wrap window in cellophane wrap

B08/04/03 (8)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Wrap in foam

Identify and Stock

Location: 9/8

8/4/4

56

(8x)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

B08/04/04

Job Completion

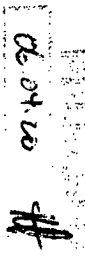


W mf

08-04-04







Technical drawing of a rectangular plate with the following dimensions and specifications:

- Overall width: 13.50
- Overall height: 8.50
- Top edge features three holes with center-to-center (C-C) spacings of 6.938, 0.344, and 0.313.
- Bottom edge features three holes with C-C spacings of 6.125, 0.313, and 0.625.
- Left edge features two holes with a C-C spacing of 0.625.
- Right edge features two holes with a C-C spacing of 0.625.
- Corner radii are specified as R0.250 (TYP).
- Internal hole diameter is specified as  $\phi 0.156$  (TYP).
- Handwritten note on the left: *200 302*

u/o 34266

- Copyright © 1994 by DART AEROSPACE LTD**
- THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**Copyright © 1984 by DART AEROSPACE LTD**



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 38266		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
08/04/03	7.	2 windows scrap <del>were too much</del> <del>scraper</del> Blow out find By the hole 1 use for new template		Scrap + asst tray wo replace Qty (x2)	 08/04/03	 08/04/03	 QSF 42	 08/04/03
		RC From Peering's from water & mat - →						

Part No: D2214 PAR #: N/A Fault Category: Production <sup>med & Small</sup> NCR: Yes No DQA: D Date: 08/04/04

NOTE: Date & initial all entries QA: N/C Closed: D Date: 08/04/04